Quality Control

	Vork Order ID 69387 esday, May 10, 2011 2:26:22 PM											Page 1
Item ID: Revision ID:	D3395-1			Α	ccept				s s	Setup Star	t	
	Bushing									Stop)	
Required Date:	5/10/2011 5/12/2011	Start Qty: 30.00 Req'd Qty: 30.00				Cust Item Customer						
Reference:				** ***********************************					ŗ	Run Star	·t	
Approvals:	Process Plan	n:	Date://-0	15-10	Tooling:	I	Date:		•		**********	
	QC:	<u> </u>	Date:		SPC (Y/N):		Date:			Stop		
Sequence ID/ Work Center ID		Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3395	Rev	Α										
Hardinge CNC Lathe	Small	Hardinge CNC LATH Memo Turn as p	IE SMALL. Her Folio FA513 and	Dwg D3395	0.00 0.00 5□Deburr	117			30	Ø		
QC Quality Control		QC2- Inspect parts off Memo	f machine FAI/FAIB	C)	0.00 0.00				70	6	<i>,</i>	
120 		QC8- Inspect parts - s	econd check		0.00	7 U · C ·	17		₹ €	B		

Dart A	Aeros	pace l	Ltd
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W/O:			wo	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·				300000			
Part No	•	PAR #:	Fault Categ	Jory:	NCR: Yes	No DQ	A:	Date:	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Resolution:		olution:	Disposition	1:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	()			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector

Work Order ID 69387

Tuesday, May 10, 2011 2:26:22 PM



Page 2

Item ID:

D3395-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Bushing

5/10/2011

Start Qty: 30.00 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

A	nn	ro	va	k:
~	มม	ı v	7 64	

Process Plan:

Date:

Tooling:

Date:

Run

Start



Required Date: 5/12/2011

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

140

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

N/5/18 78) N/1/05/18

	-								
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1100 1119	
	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1								
		·							
Part No	*	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date: _	¢
Reso		solution:	Disposition	1:	_ QA: N/C Cld	sed:		Date: _	
NCR:		\	WORK ORDE	R NON-CONFORM	ANCE (NCR)			
DATE	CTED Description of NC			ion B	Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
								1	

Picklist Print

Tuesday, May 10, 2011 2:26:28 PM

Work Order ID: 69387

Parent Item:

D3395-1

Parent Item Name: Bushing



Start Date: 5/10/2011

Required Date: 5/12/2011

Page 1

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP A□05.02.23□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINRO.500		Purchased	No			100	f	83.1000	0.0625	1.973684	11/8	€][7

Delrin Round Bar .50"

 Location
 Loc Oty
 Loc Code

 MAT055
 83.1

 109571
 33.1

 18355
 50

1.9 Df

W/O:			WC	ORK ORDER CHAN	GES					<u> </u>
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Da	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			_							
Part No	<u> </u>	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQA		 Date:	
,			Disposition: QA: N/C Closed:							
NCR:		,	WORK ORD	ER NON-CONFORM	IANCE (N	CR)	_			
DATE	STEP	Description of NC Section A	Initial Action Description			n &	Verification Section C		Approval Chief Eng	Approval QC Inspector
		<u> </u>	Chief Eng	Chief Eng	Di	ate				
		_								

DART AEROSPACE LTD	Work Order:	693837
Description: Bushing	Part Number:	D3395-1
Inspection Dwg: D3395 Rev: A		Page 1 of 1

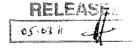
	FIRS	T ARTICLE IN	NSPECTI	ON CHE	CKLIST		
)	First Arti	cle	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ıments
0.600	+/-0.010	-602			21/2		
0.060	+/-0.010	-062					Window -
R0.010	+/-0.010	17-005					()
0.030 x 20°	0.5°	1030×26					
Ø0.500	+/-0.010	0.499					
Ø0.191	+0.005/-0.001	0.131					
Ø0.305	+/-0.010	0.306					
		Audited by	200		Prototyno		NIA
Measured by:	7777	Audited by:	` .		Prototype /		N/A
Date:	4/3/12	Date:	11. 8	17		Date:	N/A
Rev Date A 05.0714	Change New Issue					evised by	Approved

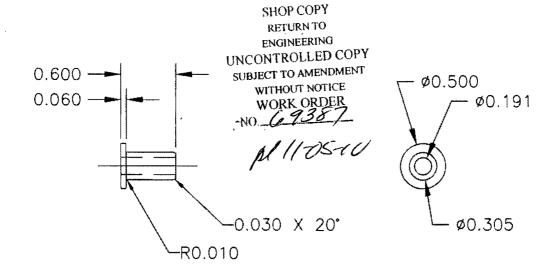
W/O:	-		WC	RK ORDER CHANGE	-s				
DATE	STEP	PRO	OCEDURE CHAI		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•									
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description		on B Sign		cation	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Date		1011 C	Officer Eng	QC Inspector

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DESIG	CP	DRAWN BY	DA	RT AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	***************************************
CHECH	ED m/	APPROVED	DRAWING NO.		REV. A
	-#-	#	D3395	SHEET	1 OF 1
DATE		·	TITLE		SCALE
 05.0	3.10		BUSHING		1:1
Α		05.03.10	NEW ISSU	E	





D3395-1 BUSHING

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:	•		WC	ORK ORDER CHANG	GES				
DATE	SŢEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	_
•	R	esolution:	Disposition	n:	QA: N/C C	osed:		Date:	
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC	Description of NC Corrective Action			Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
		•							
		-	·						
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